

Work Order ID 66187

Monday, February 07, 2011 11:53:22 AM

Page 1

Item ID: D3622-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ball Stud

Start Date: 2/8/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-02-07*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3622

Rev B

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA686 & DWG D3622,
FOLIO REV: *AD*
DWG REV: *C*
2-DEBURR AS REQUIRED

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



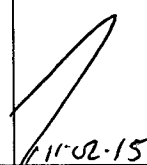
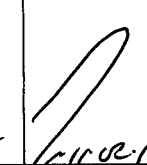
QC8- Inspect parts - second check

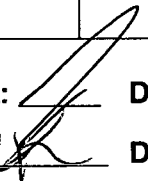
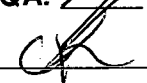
QC


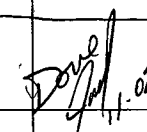

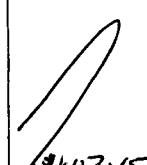
Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11-02-15	W/O Kocher	Dwg revision is now @ Rev. C, update rev. param change				 11-02-15	 11-02-15	

Part No: 03622x1 PAR #: _____ Fault Category: Prod-Unloading NCR: Yes No DQA:  Date: 11-02-15
 Resolution: Scrap Disposition: Scrap QA: N/C Closed:  Date: 11/02/16

NCR: 66187		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-2-15	100	THREAD MEASUREMENT over WIRES UNDER TOL. BY ".0064" RC WIRES NOT PLACED IN CORRECT SLOT. NEGLIGENCE OPERATOR ERROR, X20 R.C. LOA.	 11/02/15	Scrap & destroy Replace W/O qty. update Folio FA696 to reflect the current dwg revision	 11-02-16		 11/02/15	 11-02-15

NOTE: Date & initial all entries

Work Order ID 66187

Monday, February 07, 2011 11:53:22 AM

Page 2

Item ID: D3622-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Ball Stud

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg. & Stock Location: 70

0.00



Packaging

Memo

0.00

Packaging

11/2/16 J (201)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/02/16
MF
11-02-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 11:53:20 AM

Page 1

Work Order ID: 66187

Parent Item: D3622-1

Parent Item Name: Ball Stud




Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-04-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500 -  303 HEX BAR .500		Purchased	No			100	f	98.7080	0.108	2.273684		11.2.15	

Location

MAT037

109778

Loc Qty

98.708

98.708

Loc Code

2.150

2.150

4.300

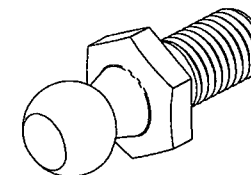
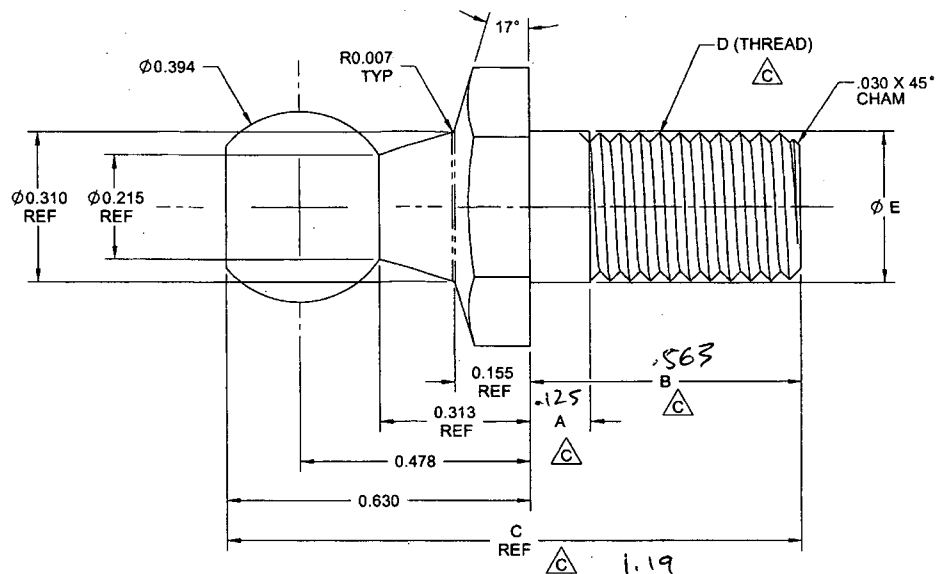
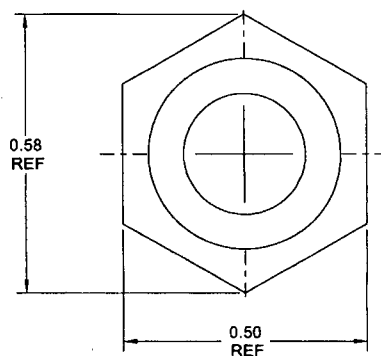
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

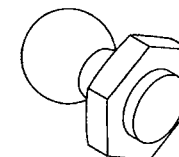
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3622-1 BALL STUD
SHOWN**



**D3622-11 BALL STUD
SHOWN**

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840 0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270 0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053 0.3125

D3622-X BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D3622	SHEET 1 OF 1
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66187
Description: D3622-1 BALL STUD		Part Number: 3622-1
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.58	+/- .030	.563	/		RQ - 02	
.50	+/- .030	.498	/			
.394	+/- .010	.393	/			
.310	+/- .010	.311	/			
.215	+/- .010	.215	/			
.155	+/- .010	.153	/			
.313	+/- .010	.315	/			
.478	+/- .010	.470	/			
.630	+/- .010	.627	/			
A .125	+/- .010	.125	/			
B .563	+/- .010	.561	/			
C 1.19	+/- .030	1.189	/			
D S/16-24	3A	3A	/			
M.D. .3125	+0.0-.0072	.309	/			
M.O.W	.3363/.3336	.335	/			

Measured by: <i>[Signature]</i>
Date: 11-2-15

Audited by: <i>[Signature]</i>
Date: 11-02-16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	